

Work Order ID 113010

February-11-14 3:18:20 PM

113010

Page 1

Item ID: D3536-23

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Gasket Center

Stop

NS2

Start Date: 2/18/14 Start Qty: 12.00

12

Cust Item ID:

Required Date: 2/18/14 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals:

Process Plan: MLS

Date: 14-02-12

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr	
D3536	Rev A	

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

12 0 Jm 14-02-20

FLOW CNC Waterjet

1-Cut as per Dwg D3536 Dwg Rev: A Prog Rev: A 2-
Deburr if necessary

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

12 0 Jm 14-02-20

Quality Control

120

QC8- Inspect parts - second check

0.00

Sh
14/2/2014

120

QC

Memo

0.00

12

Quality Control

DQA:

Date:



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed:

Date:

Work Order update only

Work Order:				DISPOSITION		AGAINST DEPARTMENT/PROCESS																																																	
				Rework <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>																																															
				Scrap <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>																																															
				Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>																																															
				Suspected Unapproved <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																																																
Root Cause		Date	Step	Qty	Description of work order update or non-conformance		Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector																																												
Design																																																							
Doc/Data																																																							
Equip/Tooling																																																							
Handling/Pre																																																							
Material																																																							
Operator																																																							
Offset/Setup																																																							
Process																																																							
Supplier																																																							
Training																																																							
Transport																																																							
Unapproved																																																							
FAULT CATEGORY																																																							
Landing Gear				General																																																			
<input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube				<table border="0"> <tr> <td><input type="checkbox"/> Bend</td> <td><input type="checkbox"/> Folio/Program</td> <td><input type="checkbox"/> Outside Dimensions</td> <td><input type="checkbox"/> Pressure/Forced</td> </tr> <tr> <td><input type="checkbox"/> BOM/Route</td> <td><input type="checkbox"/> Grain</td> <td><input type="checkbox"/> Over/Under tolerance</td> <td><input type="checkbox"/> Set-up</td> </tr> <tr> <td><input type="checkbox"/> Broken/Damage/Defect</td> <td><input type="checkbox"/> Hardware</td> <td><input type="checkbox"/> Part Incorrect</td> <td><input type="checkbox"/> Temperature/Cure</td> </tr> <tr> <td><input type="checkbox"/> Burrs</td> <td><input type="checkbox"/> Inspection Incomplete/Unqualified</td> <td><input type="checkbox"/> Part Lost/Missing</td> <td><input type="checkbox"/> Weld</td> </tr> <tr> <td><input type="checkbox"/> Contamination</td> <td><input type="checkbox"/> Instructions Incomplete/Unclear</td> <td><input type="checkbox"/> Part Moved</td> <td><input type="checkbox"/> Wrong Stock Pulled</td> </tr> <tr> <td><input type="checkbox"/> Countersink</td> <td><input type="checkbox"/> Misaligned/off center</td> <td><input type="checkbox"/> Positioned Wrong</td> <td></td> </tr> <tr> <td><input type="checkbox"/> Cut Too Short</td> <td><input type="checkbox"/> Mislabeled</td> <td><input type="checkbox"/> Power Loss/Surge</td> <td></td> </tr> <tr> <td><input type="checkbox"/> Drawing</td> <td><input type="checkbox"/> Misread</td> <td></td> <td></td> </tr> <tr> <td><input type="checkbox"/> Drill Holes</td> <td><input type="checkbox"/> Off-set</td> <td></td> <td></td> </tr> <tr> <td><input type="checkbox"/> Finish</td> <td><input type="checkbox"/> Out of Calibration</td> <td></td> <td></td> </tr> <tr> <td><input type="checkbox"/> Fit/Function</td> <td><input type="checkbox"/> Out of Sequence</td> <td></td> <td></td> </tr> </table>								<input type="checkbox"/> Bend	<input type="checkbox"/> Folio/Program	<input type="checkbox"/> Outside Dimensions	<input type="checkbox"/> Pressure/Forced	<input type="checkbox"/> BOM/Route	<input type="checkbox"/> Grain	<input type="checkbox"/> Over/Under tolerance	<input type="checkbox"/> Set-up	<input type="checkbox"/> Broken/Damage/Defect	<input type="checkbox"/> Hardware	<input type="checkbox"/> Part Incorrect	<input type="checkbox"/> Temperature/Cure	<input type="checkbox"/> Burrs	<input type="checkbox"/> Inspection Incomplete/Unqualified	<input type="checkbox"/> Part Lost/Missing	<input type="checkbox"/> Weld	<input type="checkbox"/> Contamination	<input type="checkbox"/> Instructions Incomplete/Unclear	<input type="checkbox"/> Part Moved	<input type="checkbox"/> Wrong Stock Pulled	<input type="checkbox"/> Countersink	<input type="checkbox"/> Misaligned/off center	<input type="checkbox"/> Positioned Wrong		<input type="checkbox"/> Cut Too Short	<input type="checkbox"/> Mislabeled	<input type="checkbox"/> Power Loss/Surge		<input type="checkbox"/> Drawing	<input type="checkbox"/> Misread			<input type="checkbox"/> Drill Holes	<input type="checkbox"/> Off-set			<input type="checkbox"/> Finish	<input type="checkbox"/> Out of Calibration			<input type="checkbox"/> Fit/Function	<input type="checkbox"/> Out of Sequence		
<input type="checkbox"/> Bend	<input type="checkbox"/> Folio/Program	<input type="checkbox"/> Outside Dimensions	<input type="checkbox"/> Pressure/Forced																																																				
<input type="checkbox"/> BOM/Route	<input type="checkbox"/> Grain	<input type="checkbox"/> Over/Under tolerance	<input type="checkbox"/> Set-up																																																				
<input type="checkbox"/> Broken/Damage/Defect	<input type="checkbox"/> Hardware	<input type="checkbox"/> Part Incorrect	<input type="checkbox"/> Temperature/Cure																																																				
<input type="checkbox"/> Burrs	<input type="checkbox"/> Inspection Incomplete/Unqualified	<input type="checkbox"/> Part Lost/Missing	<input type="checkbox"/> Weld																																																				
<input type="checkbox"/> Contamination	<input type="checkbox"/> Instructions Incomplete/Unclear	<input type="checkbox"/> Part Moved	<input type="checkbox"/> Wrong Stock Pulled																																																				
<input type="checkbox"/> Countersink	<input type="checkbox"/> Misaligned/off center	<input type="checkbox"/> Positioned Wrong																																																					
<input type="checkbox"/> Cut Too Short	<input type="checkbox"/> Mislabeled	<input type="checkbox"/> Power Loss/Surge																																																					
<input type="checkbox"/> Drawing	<input type="checkbox"/> Misread																																																						
<input type="checkbox"/> Drill Holes	<input type="checkbox"/> Off-set																																																						
<input type="checkbox"/> Finish	<input type="checkbox"/> Out of Calibration																																																						
<input type="checkbox"/> Fit/Function	<input type="checkbox"/> Out of Sequence																																																						

Work Order ID 113010

113010

Page 2

February-11-14 3:18:20 PM

Item ID: D3536-23

Accept

N900040100

Setup

Start

NS1

Revision ID:

Item Name: Gasket Center

Stop

NS2

Start Date: 2/18/14 Start Qty: 12.00

12

Cust Item ID:

Required Date: 2/18/14 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals:

Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run

Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

Identify as per dwg & Stock Location: FP-601 0.00

130

Packaging

Packaging

X13 4/11/14 21

140

QC21- Final Inspection - Work Order Release 0.00

140

QC

Quality Control

11/14/2014

11/14/2014

DQA:

Date:



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed:

Date:

Work Order update only

Work Order: _____			DISPOSITION			AGAINST DEPARTMENT/PROCESS					
Part No. _____			Rework <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>				
NCR No. _____			Scrap <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>				
			Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>				
			Suspected Unapproved <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>					
Root Cause	Date	Step	Qty	Description of work order update or non-conformance		Initial Chief Eng	Action Description		Sign & Date	Verification	QC Inspector
Design											
Doc/Data											
Equip/Tooling											
Handling/Pre											
Material											
Operator											
Offset/Setup											
Process											
Supplier											
Training											
Transport											
Unapproved											
FAULT CATEGORY											
Landing Gear				General							
				Bending <input type="checkbox"/>	Bend <input type="checkbox"/>	Folio/Program <input type="checkbox"/>	Outside Dimensions <input type="checkbox"/>	Pressure/Forced <input type="checkbox"/>			
				Centre Not Concentric <input type="checkbox"/>	BOM/Route <input type="checkbox"/>	Grain <input type="checkbox"/>	Over/Under tolerance <input type="checkbox"/>	Set-up <input type="checkbox"/>			
				Cracks <input type="checkbox"/>	Broken/Damage/Defect <input type="checkbox"/>	Hardware <input type="checkbox"/>	Part Incorrect <input type="checkbox"/>	Temperature/Cure <input type="checkbox"/>			
				Crimp/Kink/Ripple/Wave <input type="checkbox"/>	Burrs <input type="checkbox"/>	Inspection Incomplete/Unqualified <input type="checkbox"/>	Part Lost/Missing <input type="checkbox"/>	Weld <input type="checkbox"/>			
				Cuffs <input type="checkbox"/>	Contamination <input type="checkbox"/>	Instructions Incomplete/Unclear <input type="checkbox"/>	Part Moved <input type="checkbox"/>	Wrong Stock Pulled <input type="checkbox"/>			
				Crushing <input type="checkbox"/>	Countersink <input type="checkbox"/>	Misaligned/off center <input type="checkbox"/>	Positioned Wrong <input type="checkbox"/>				
				Heat Treat <input type="checkbox"/>	Cut Too Short <input type="checkbox"/>	Mislabeled <input type="checkbox"/>	Power Loss/Surge <input type="checkbox"/>				
				Inspection Strip in Tube <input type="checkbox"/>	Drawing <input type="checkbox"/>	Misread <input type="checkbox"/>					
				Marks/Chatter <input type="checkbox"/>	Drill Holes <input type="checkbox"/>	Off-set <input type="checkbox"/>					
				Turning Sequence <input type="checkbox"/>	Finish <input type="checkbox"/>	Out of Calibration <input type="checkbox"/>					
				Wave/Twist in Tube <input type="checkbox"/>	Fit/Function <input type="checkbox"/>	Out of Sequence <input type="checkbox"/>					

Picklist Print

Page 1

February-11-14 3:18:23 PM

Work Order ID: 113010

113010
D3536-23

Parent Item: D3536-23

Parent Item Name: Gasket Center

Start Date: 2/18/14

Required Date: 2/18/14

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A New Issue 07-02-14 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MNEO60S.063		Purchased	No			100	sf	27.1000	1.3365	17.82	**	18	

MNEO60S.063

NEOPRENE SHEET 0.063

Location	Loc Qty	Loc Code
MAT052	27.1	
M126546	27.1	

128266

128266

Jn 14-02-20

DQA:

Date:



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed:

Date:

Work Order update only

Work Order:	DISPOSITION			AGAINST DEPARTMENT/PROCESS					
Part No.	Rework <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>				
NCR No.	Scrap <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>				
	Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>				
	Suspected Unapproved <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>					
Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									
FAULT CATEGORY									
Landing Gear	General								
	Bending	Bend <input type="checkbox"/>	Folio/Program <input type="checkbox"/>						
	Centre Not Concentric	BOM/Route <input type="checkbox"/>	Grain <input type="checkbox"/>						
	Cracks	Broken/Damage/Defect <input type="checkbox"/>	Hardware <input type="checkbox"/>						
	Crimp/Kink/Ripple/Wave	Burrs <input type="checkbox"/>	Inspection Incomplete/Unqualified <input type="checkbox"/>						
	Cuffs	Contamination <input type="checkbox"/>	Instructions Incomplete/Unclear <input type="checkbox"/>						
	Crushing	Countersink <input type="checkbox"/>	Misaligned/off center <input type="checkbox"/>						
	Heat Treat	Cut Too Short <input type="checkbox"/>	Mislabeled <input type="checkbox"/>						
	Inspection Strip in Tube	Drawing <input type="checkbox"/>	Misread <input type="checkbox"/>						
	Marks/Chatter	Drill Holes <input type="checkbox"/>	Off-set <input type="checkbox"/>						
	Turning Sequence	Finish <input type="checkbox"/>	Out of Calibration <input type="checkbox"/>						
	Wave/Twist in Tube	Fit/Function <input type="checkbox"/>	Out of Sequence <input type="checkbox"/>						

DART AEROSPACE LTD		Work Order:	113010
Description: Gasket		Part Number:	D3536-23
Inspection Dwg: D3536	Rev: A		Page 1 of 1

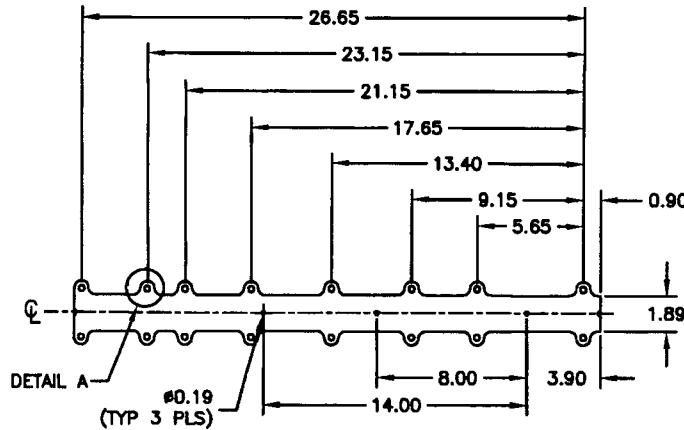
FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
52.85	+/-0.030	52.85"	-		T	Jkmolc
48.20	+/-0.030	48.20"	-		T	
44.70	+/-0.030	44.70"	-		T	
39.31	+/-0.030	39.31"	-		T	
33.92	+/-0.030	33.92"	-		T	
28.53	+/-0.030	28.53"	-		T	
23.14	+/-0.030	23.14"	-		T	
17.75	+/-0.030	17.75"	-		T	
14.25	+/-0.030	14.25"	-		T	
9.50	+/-0.030	9.50"	-		T	
4.75	+/-0.030	4.75"	-		V	Jkmol1
8.00	+/-0.030	8.00"	-		V	
16.00	+/-0.030	16.00"	-		T	
24.00	+/-0.030	24.00"	-		T	
32.00	+/-0.030	32.00"	-		T	
39.00	+/-0.030	39.00"	-		T	
48.00	+/-0.030	48.00"	-		T	
0.30	+/-0.030	0.30"	-		V	
0.30	+/-0.030	0.30"	-		V	
1.89	+/-0.030	1.89"	-		V	
Ø0.19	+0.005/-0.001	0.19"	-		V	

Measured by:	Jm	Audited by:	Shp	Prototype Approval:	N/A
Date:	14.02.20	Date:	18/2/24	Date:	N/A

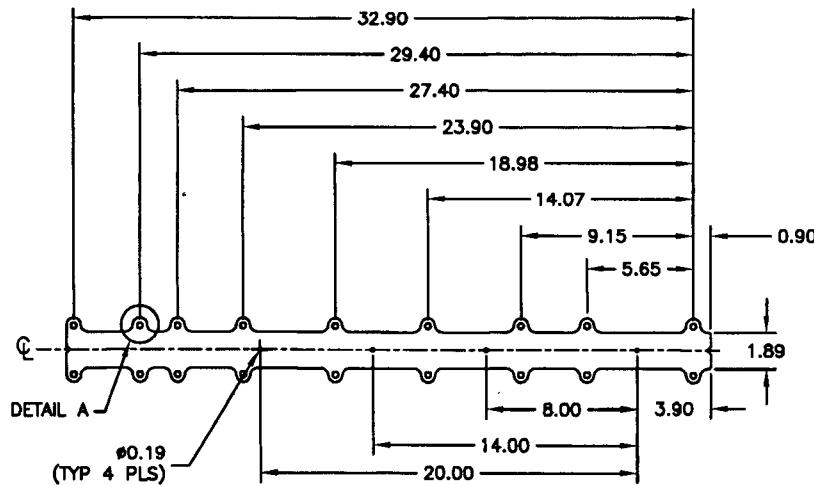
Rev	Date	Change	Revised by	Approved
A	07.03.14	New Issue	KJ/JLM	Shp



D3536-11 GASKET

NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NE060-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT \mathcal{Q}
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION



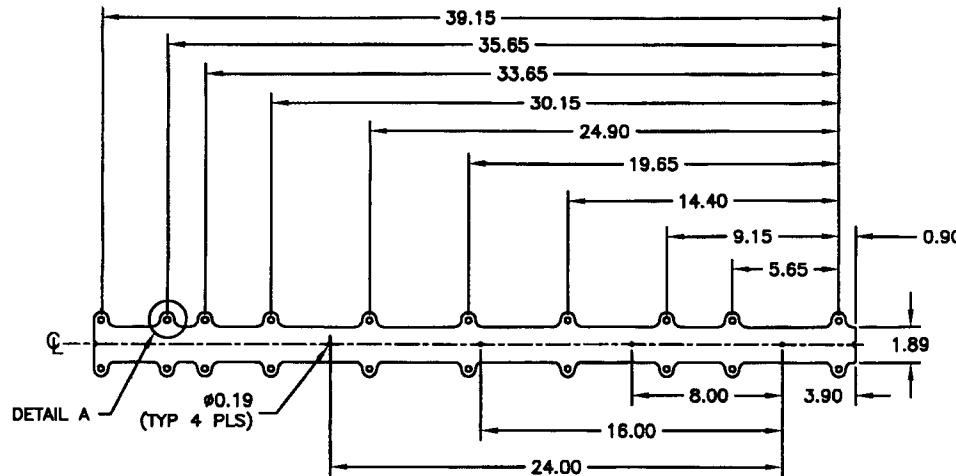
D3536-13 GASKET

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
C B	C B	PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO.
<i>PH</i>	<i>PH</i>	D3536
DATE		SCALE
06.10.25	06.10.25	1:10
A	06.10.25	NEW ISSUE

09-02-12
RELEASED

UNC

113010 MJS
14-02-12

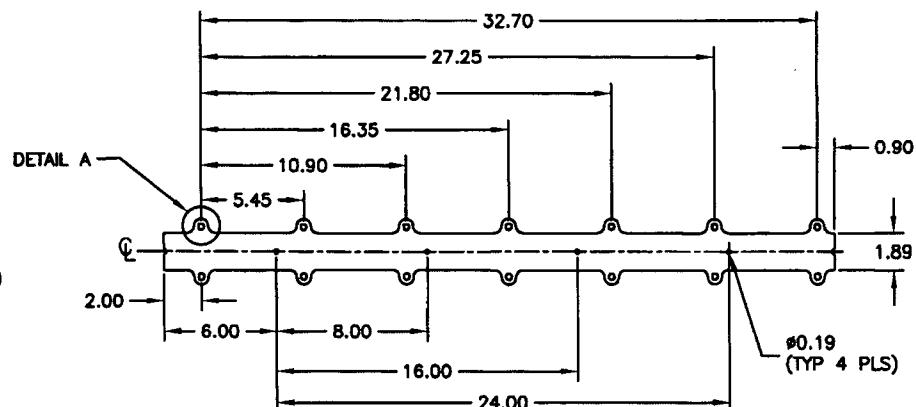


D3536-15 GASKET

07.02.12
H

DART

DESIGN CB	DRAWN BY CB	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED PH	APPROVED PH	DRAWING NO. D3536
DATE 06.10.25		TITLE GASKET
		REV. A SHEET 2 OF 6 SCALE 1:10



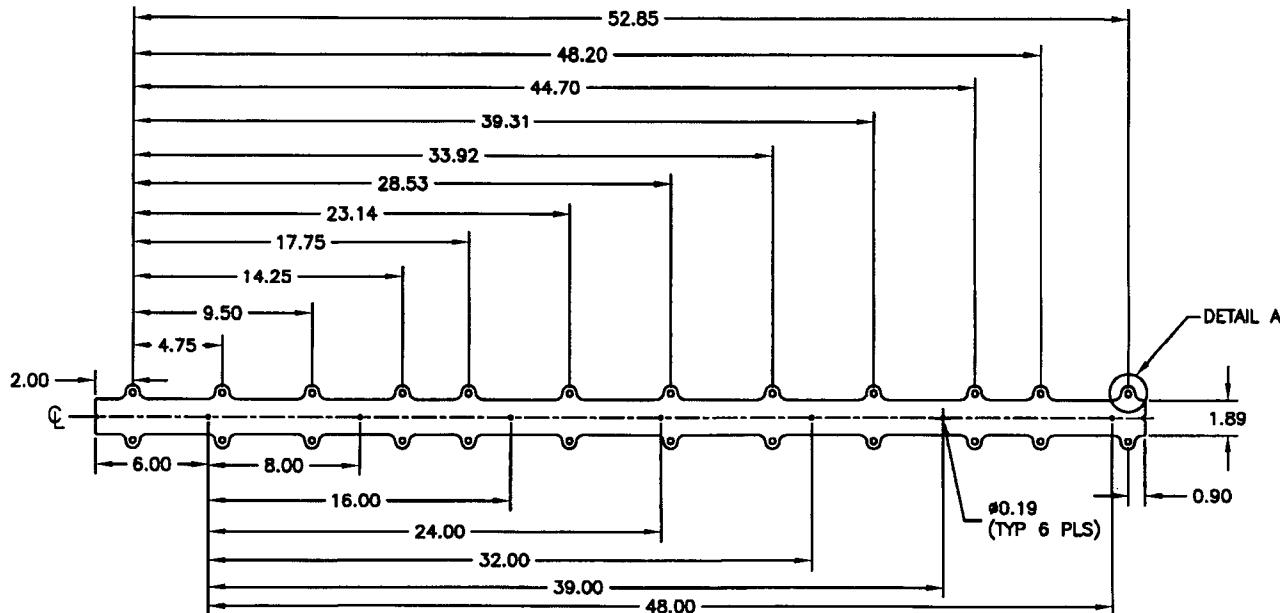
NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT $\frac{1}{2}$
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION

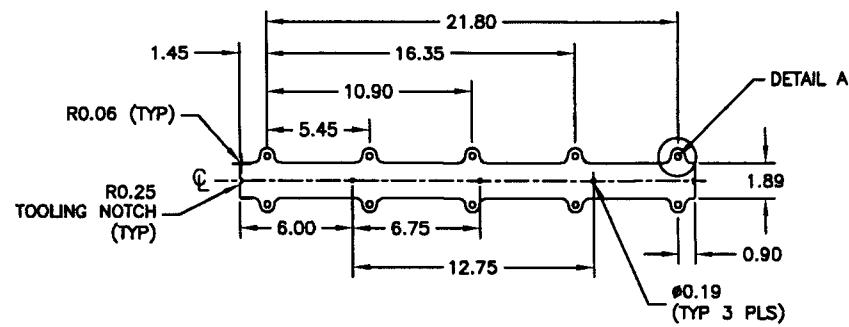
D3536-21 GASKET

NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NE060-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT $\frac{C}{2}$
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION



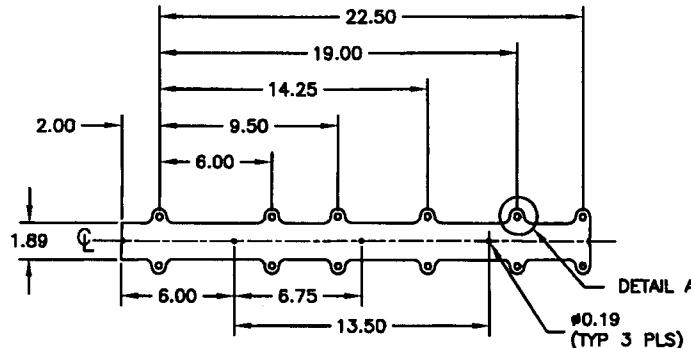
D3536-23 GASKET



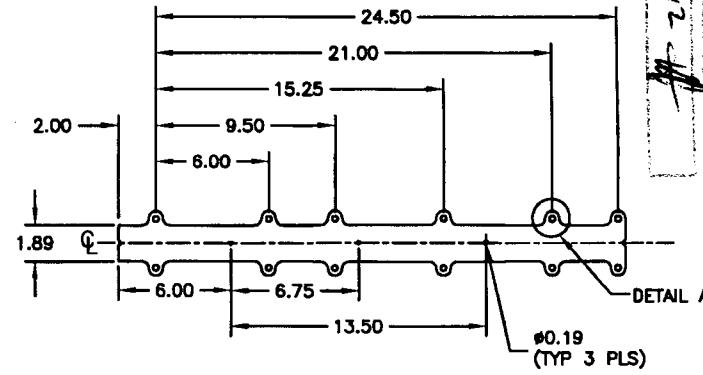
D3536-25 GASKET

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
C B	C B	PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO.
P4	H	D3536
DATE		TITLE
06.10.25		GASKET
REV. A		SHEET 3 OF 6
SCALE		1:10

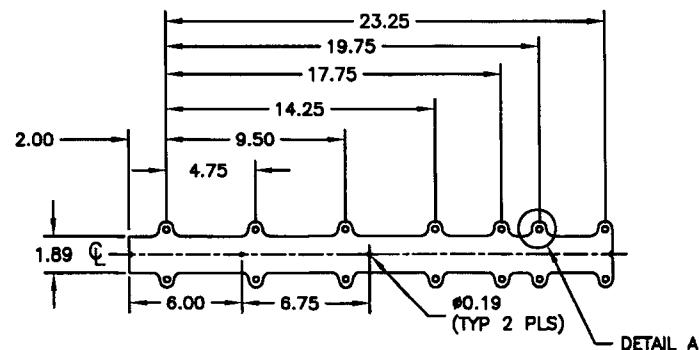
DART



D3536-31 GASKET



D3536-33 GASKET



D3536-35 GASKET

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
C.B	C.B	PRT HADLOCK, WA
CHECKED	APPROVED	REV. A
P.H	H	
DATE		REV. A
06.10.25		
DRAWING NO.	TITLE	SCALE
D3536	GASKET	1:10
SHEET	4 OF 6	

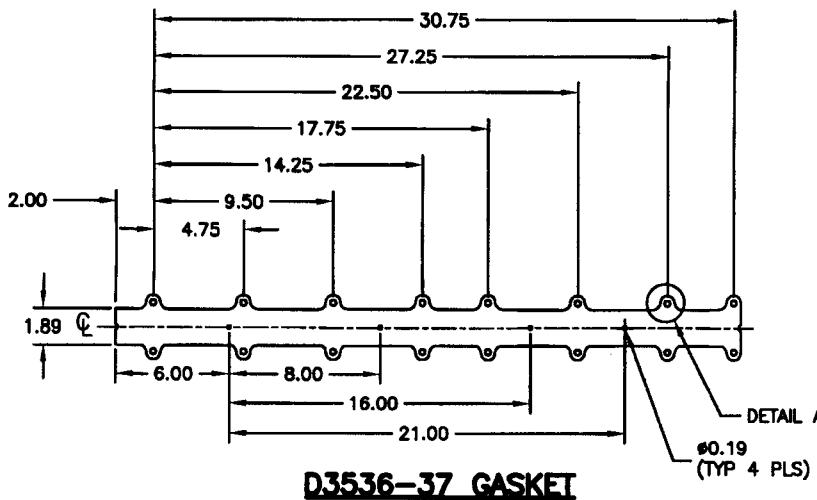
DART

07.02.12 - H

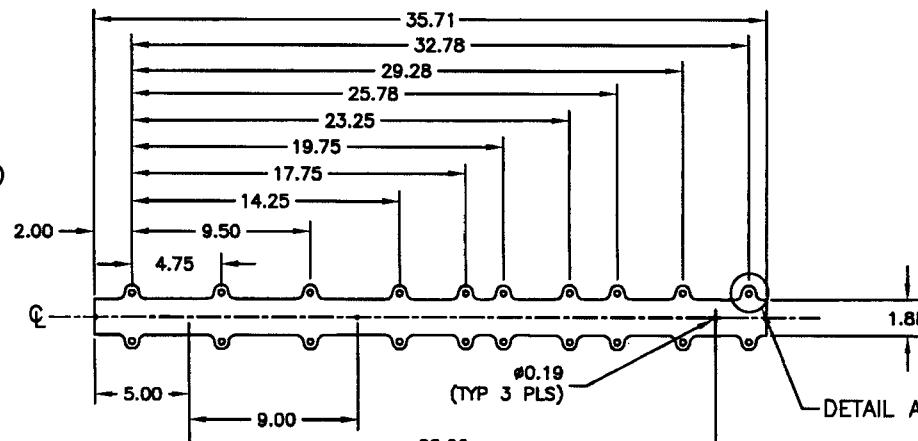
DART

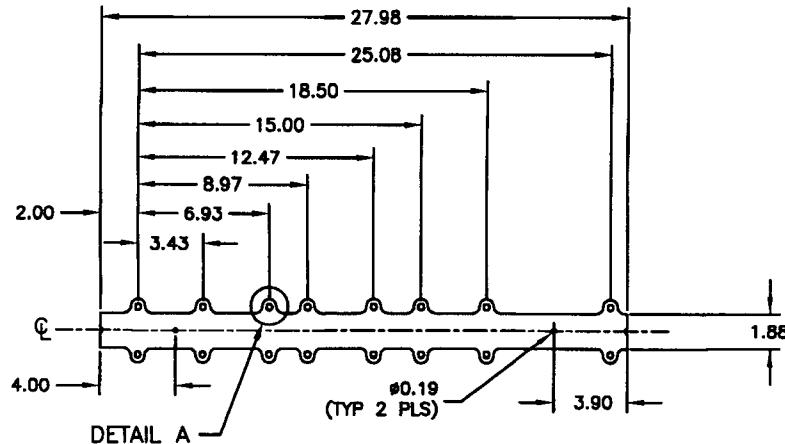
DESIGN CB	DRAWN BY CB	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED PH	APPROVED PH	DRAWING NO. D3536
DATE 06.10.25	TITLE GASKET	REV. A SHEET 5 OF 6 SCALE 1:10

07.02.02
[Signature]

**D3536-37 GASKET****NOTES**

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT $\frac{1}{4}$
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION

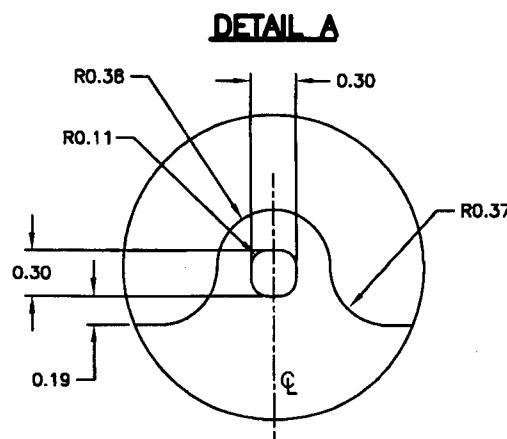
**D3536-39 GASKET**



D3536-41 GASKET

NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT $\frac{Q}{2}$
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER



DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
CB	CB	PORT HADLOCK, WA
CHECKED	APPROVED	REV. A
PH	PH	DRAWING NO.
		D3536
DATE		SCALE
06.10.25		1:10
TITLE		SHEET 6 OF 6
GASKET		

07.02.12